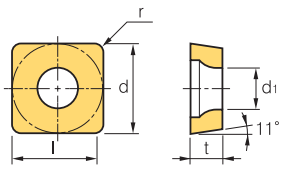
SP ○○

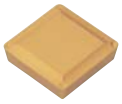
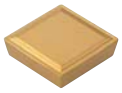
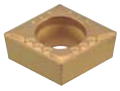
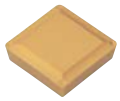
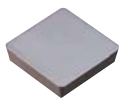
Square 90° Positive
Relief Angle: 11°



Dimensions (mm)			
Size	d	t	d1
09	9.525	3.18	3.4~4.4
12	12.7	3.18	-
15	15.875	4.76	-
19	19.05	4.76	-
25	25.4	6.35	-

Workpiece		CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05
Steel	P	●	⬌	✱	●	⬌	●	⬌	⬌	✱	✱	●	●	⬌		✱								
Stainless steel	M									⬌	⬌			●	⬌	✱	⬌	✱		●	⬌	⬌		
Cast iron	K	●	⬌	✱	●	⬌	⬌				⬌	⬌	⬌										●	⬌
Non-ferrous metal	N																						●	⬌
Heat resistant alloy, Titanium alloy	S										●				●	●	⬌	✱	●	●	⬌		●	⬌
Hardened steel	H																			⬌	✱		●	⬌

Machining types
- ● Continuous cutting
- ⬌ General cutting
- ✱ Interrupted cutting

Inserts		Designation		Cermet			Coated		Coated														Uncoated		Cutting Condition	
				CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05	fn (mm/rev)	ap (mm)
Medium cutting	M 	SPGR	090308-M																								0.10~0.40	1.00~3.50
			120308-M																								0.20~0.40	1.50~4.00
Medium to finishing		SPGT	090304R																								0.08~0.23	0.30~3.00
			090308R																								0.10~0.30	0.50~3.00
			090304L		●																						0.08~0.23	0.30~3.00
			090308L																								0.10~0.30	0.50~3.00
Finishing	F 	SPMR	090304-F																								0.05~0.20	0.30~2.00
			120304-F								●	●															0.10~0.25	0.50~2.00
Finishing	VL 	SPMT	09T304-VL																								0.04~0.18	0.20~1.40
			09T308-VL																								0.08~0.22	0.20~1.40
Finishing	VF	SPMT	090304-VF																								0.05~0.20	0.30~1.50
			090308-VF																								0.10~0.25	0.30~1.50
Medium cutting	M 	SPMR	090308-M								●	●															0.10~0.40	1.00~3.50
			120308-M								●	●															0.10~0.40	1.50~4.00
			120312-M									●															0.20~0.40	1.50~4.00
Medium to finishing		SPUN	120304																								0.10~0.30	1.00~5.00
			120308																								0.15~0.40	1.00~5.00
			120308SN																								0.15~0.40	1.00~5.00
			150412																								0.20~0.50	1.00~5.00
			190412									●															0.20~0.50	1.50~7.00
			190416																								0.25~0.60	2.00~7.00
			250620																								0.30~0.80	3.00~10.0

Cutting edge geometry A52~A61 Recommended chip breaker B04~B11 Code system B26~B27

● : Stock item

Available tool holders			
Designation	Page	Designation	Page
CSDPN	B169	SSKPR/L	B208
CSKPR/L	B170		